

Work Order ID 81629

81629

Page 1

Friday, March 16, 2012 10:04:47 AM

Item ID: D3874-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Protector
 Start Date: 3/15/2012 Start Qty: 2.00 *2*4 Cust Item ID:
 Required Date: 3/21/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: mc Date: 12-03-16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3874	Rev A								
100		0.00							
100						x 4			Wh 12/03/20
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	I-Cut Sheet to required Blank size								
105		0.00							
105	Dry Material					x 4			Wh 12/03/20
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240°F</u>								
	Time IN: <u>7:00 pm 12/03/19</u>								
	Time OUT: <u>5:00 am 12/03/20</u>								

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Item ID: D3874-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Floor Protector

Stop ***NS2***

Start Date: 3/15/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/21/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474
Dwg Rev: A
Folio Rev: B

x 4

12/03/20

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x 4

12/03/20

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

x 4

12/03/20

Picklist Print

Friday, March 16, 2012 10:04:46 AM

Page 1

Work Order ID: 81629

Parent Item: D3874-1

Parent Item Name: Floor Protector

Start Date: 3/15/2012

Required Date: 3/21/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A 09.02.06 New Issue DL
Material 10/04/21 DL

IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	1,458.7869	4.38	8.76			

Location

Loc Qty

Loc Code

therm

113127

1458.786941

1458.78694

17.52 sq ft

12/03/21

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector		Part Number:	D3874-1
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Sh. Date: 12/03/20

TRIMMING SECTION

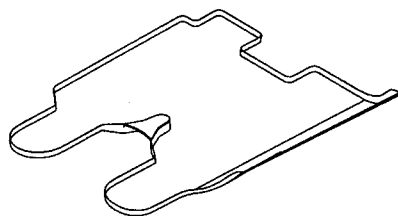
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.061"	✓		Vern DL-02	
0.065	Min	0.094"	✓		CAL TH-DT	
0.5	Min	0.54"	✓		Vern DL-02	

Measured by: Sh. Date: 12/03/21

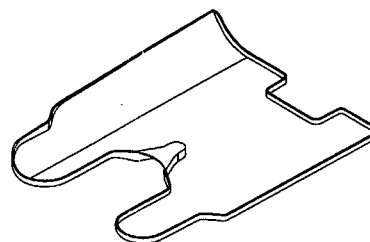
Audited by: B Date: 12.03.26

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>Sh.</u>



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

81629

RELEASED
29/05/17

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1

D

C

B

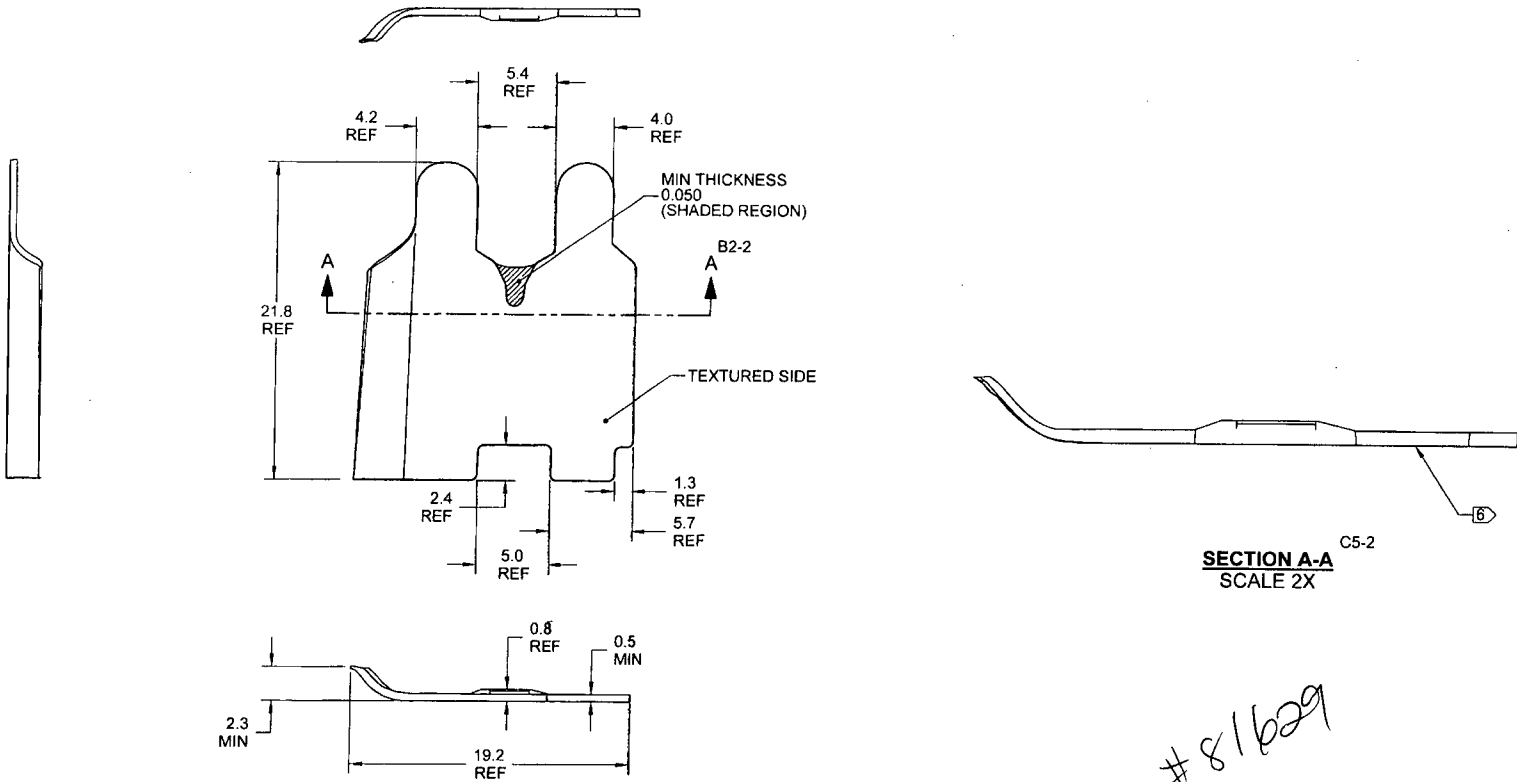
A

D

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B

A



D3874-1 FLOOR PROTECTOR

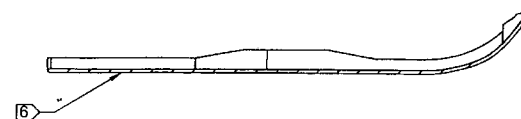
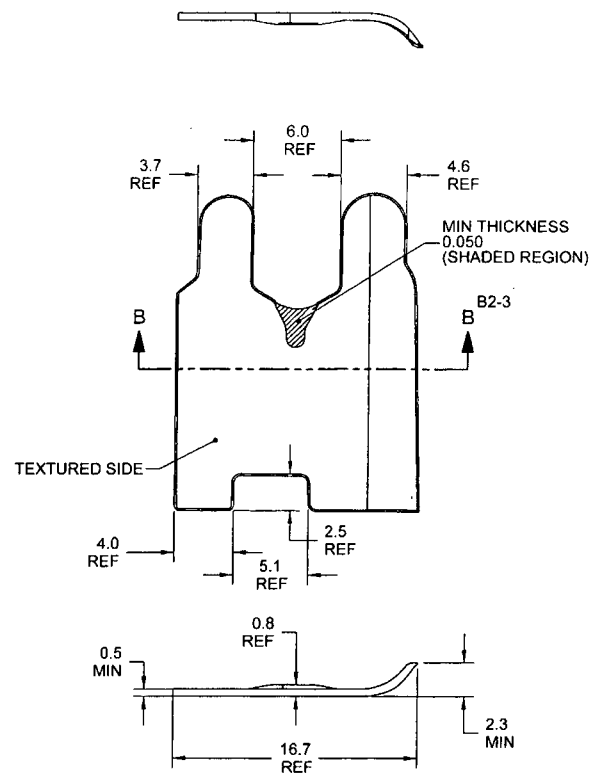
RELEASED
8/25/54

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

DESIGN	PM	DART AEROSPACE LTD	
DRAWN	PM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO. D3874	REV. A
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8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

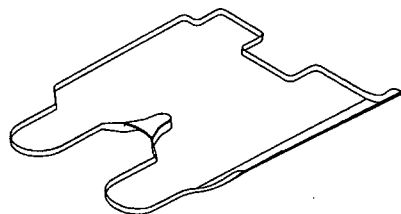
NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

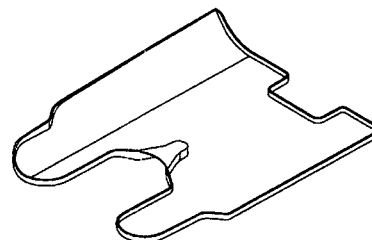
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MFG. APPR.		D3874	SHEET 3 OF 3
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RELEASED
2/15/05

81629



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

RELEASED
28/05/05

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 1 OF 3
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